



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-12-1

Job Sheet 177501



Part No: C3-12-1

Job Qty: 20 ea

Part Name: Lock Bushing



Part Weight: 0 lbs

Job Created: 5/14/18

Due Date: 5/31/18

Type: Stock

Status: At-Planning

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: C3-12-1 REV.7A IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	5/31/18	5/31/18	0.00	0.00	Start Up Machining-4		
120	Mori Seiki	20 pcs	5/31/18	5/31/18	0.50	2.50	MORI SL-154		
130	QC	20 pcs	5/31/18	5/31/18	0.00	0.00	QC2 Machining-5		
140	QC	20 pcs	5/31/18	5/31/18	0.00	0.00	QC8 Machining-5		
150	Outsource	20 pcs	5/31/18	5/31/18			MEI001-VC	5	
180	Outsource	20 pcs	5/31/18	5/31/18			GRO002-VC	10	
190	Packaging	20 pcs	5/31/18	5/31/18	0.00	0.00	Packaging2		
200	QC	20 pcs	5/31/18	5/31/18	0.00	0.00	QC6		
210	Packaging	20 pcs	5/31/18	5/31/18	0.00	0.00	Packaging3-2		
220	QC21-FG	20 Ea	5/31/18	5/31/18	0.00	0.00	QC21		

Part Op 150 - 1-Issue P/O to Metcore ; P/O 040526 HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60

Descriptions: HREW MIN) NOTE: DETAIL C OF C REQUIRED Part made from 4140 Round Bar .750 Metcor to ship directly to Groupe

DAS

45

9-89

Altech

180 - ISSUE P/O TO GROUPE ALTECH

TO .0004-.0006 C OF C IS REQUIRED

QQ-N-290, CLASS 2 GRADE E OR F. NICKEL PLATE

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R0.750	4140 Round Bar .750	.8000 ft (.04 ea)	90-Start up Operation	548046

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140H-R0.750	1	15	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Part Specifications

could not be found.

Container No: S094886



Part: C3-12-1

Job No: 177501

Serial No/Batch: S094886

Revision: 7A

Inspector:

Exp Date:

Instructions:

Date: 07/23/18

Plex 5/14/18 11:28 AM Dart.lajeunesse.marie

0927

36"

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



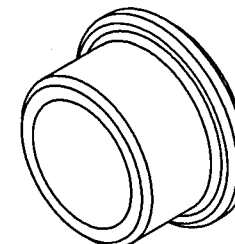
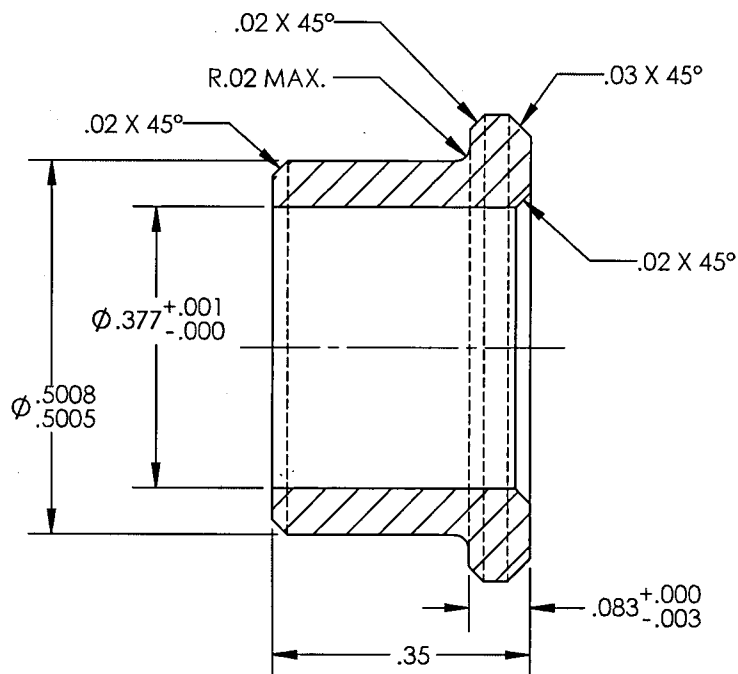
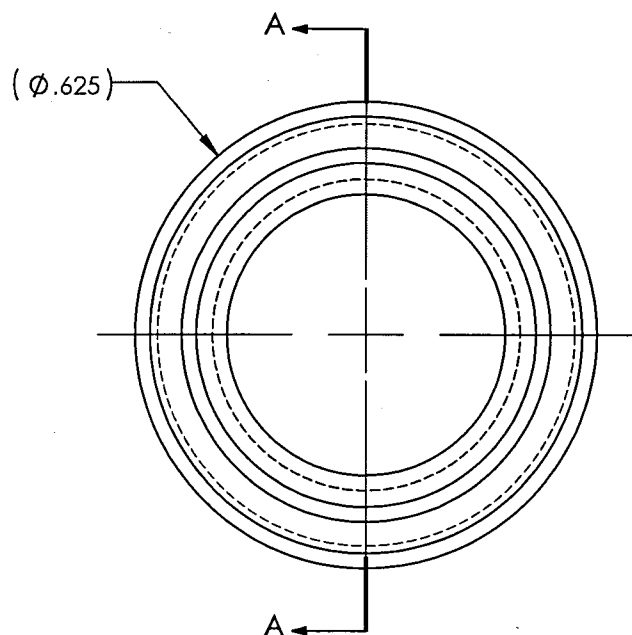
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6		CH'D Ø.499 TO Ø.5008 - .5005	8/15/2012	JAG	
7		CH'D RADIUS WAS R.015 MAX. IS R.02 MAX. ADDED NOTE 1.	8/6/2013	RJC	
7A	14-0111	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE. CH'D DIMENSION Ø.625 TO REF., CH'D DIMENSION WAS .350 IS .35.	8/7/2014	DJN	RW



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 177501 MWS
18-05-14

NOTES:

1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
2. BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK BUSHING	
DWG NO. C3-12-1	REV 7A
MAT'L 4140	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D West</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT RC 44-46
.XX ± .01 ANGLES ± 5°	FINISH SEE NOTE 1
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 4:1	DATE 11/2/2001 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			C3-12-1	1	LOCK BUSHING	4140	Ø5/8 X 1/2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																									



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040566**

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO040566
PO Date: 7/23/18
Due Date: 8/8/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177501	C3-12-1	Lock Bushing 1-Issue P/O to Metcore ; P/O _____ Part is 4140 Heat treat to 44-46 RC Metcor to ship directly to Groupe Altech	Firmed	-	8/8/18	20 pcs	0 pcs	20 pcs	\$7.50/pcs	\$150.00
	180446			Firmed	-	8/8/18	20 pcs	0 pcs	20 pcs	\$7.50/pcs	\$150.00
Sub Total:							40	0	40		\$300.00

2	178512	C3-3-4	Link Pin 1-Issue P/O to Metcor; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcor to ship directly to Groupe Altech*** Mat'l Drill Rod (A-2)	Firmed	-	7/31/18	20 pcs	0 pcs	20 pcs	\$15.10/pcs	\$302.00
---	--------	--------	--	--------	---	---------	--------	-------	--------	-------------	----------

Grand Total: \$602.00

Order Notes

CE

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Order Notes

, Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/25/18 7:59 AM dart.tsimiklis.chrisoula

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
329321	1	129979

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

LIVRÉ À /Shipped To

GROUP ALTECH
2455 ALPERN
ST LAURENT, QC H4S1N9
Ph: 613-632-5200
Fax: 613-632-1053

329321-1

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
40566		4140	7/23/2018	CLIENT

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
40	C3-12-1			.4
	(40) C3-12-1			
	JOB 177501; 180446			
	1 BOITE DE CARTON			DAS 38 9-89

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 40
POIDS EXPÉDIÉ / Weight Shipped : 0.40
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0.00

QUANTITÉ EXPÉDIÉE /Quantity Shipped: 40

POIDS EXPÉDIÉ / Weight Shipped : 0.40

Signature:

Date:

METCOR INC.

COPIE

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGE load
329321	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

GROUP ALTECH

2455 ALPERN

ST LAURENT

QC H4S1N9

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40566	N/A	4140		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	44 - 46 HRC		8	45 - 46 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
40	0.4	C3-12-1 (40) C3-12-1 JOB 177501; 180446 1 BOITE DE CARTON		
		DAS 38 9-89		

DAS
38
9-89

COMMENTAIRES / comments

SALT HARDEN 1550F, 1 HR
SNPA TEMPER 400F, 2 HRS
TEMPER 600F, 3 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été fait par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

Isabel Otero



03 AOUT 2010



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040680

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040680
PO Date: 8/3/18
Due Date: 8/10/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177501	C3-12-1	Lock Bushing ISSUE P/O TO GROUPE ALTECH: QQ-N-290, CLASS 2 GRADE E OR F. NICKEL PLATE TO .0004-.0006 C OF C IS REQUIRED	Firmed	-	8/10/18	20 pcs	0 pcs	20 pcs	\$3.00/pcs	\$60.00
	180446			Firmed	-	8/10/18	20 pcs	0 pcs	20 pcs	\$3.00/pcs	\$60.00
Sub Total:							40	0	40		\$120.00

Grand Total: \$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material Identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

DAS
38
9-89

Plex 8/3/18 11:39 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(011527-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

011527 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
06-Aug-2018		Aman		040680				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	C3-12-1 Rev. 177501	C3-12-1 01 - E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290 CLASS 2 GREADE E OR F 0.0004 - 0.0006 THICK	E-NICKEL-500 CH	40	40	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.